

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029433**Date Inspected:** 19-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge Manufacture**Location:** Reedsport, Oregon**CWI Name:** Mike Inman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Supplemental Cable Band Collar**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present at American Bridge Manufacture for observations related to welding, fabrication and Inspection performed for the Supplemental Cable Band Collar scheduled for this project. While onsite the QA Inspector observed the following.

At the time of arrival, the QA Inspector met with ABM Quality Control (QC) Inspector and discussed the welding, Non-Destructive testing (NDT) and other project related operations scheduled for this project for this date.

Supplemental Cable Band Collar Fit-up & Welding - CCO # 274

The QA Inspector periodically observed ABM personnel Mike Hebert performing base material preparation, fit-up and welding operations. The fit-up operation was being performed to attach assembly plate members to continue making the Supplemental Cable Band Collar identified as number 7, 15, 13 and 8. (A total of four plates will be attached to top and four plates on bottom of the assembly, additionally two cap plates on the top and two cap plates on the bottom).

During the fit-up in progress and after the plate members were aligned and taked welded, the QA Inspector observed ABM welding personnel performing welding operations. The welding operation was being performed by using the Flux Cored Arc Welding Gas Shielded (FCAW-G) process to make fillet welds in the horizontal position. The QA Inspector verified the electrical welding parameters that appeared to be general compliance with the referenced WPS number ABM-SAS-07.

The QA Inspector observed QC Inspector monitoring the fit-up and welding operations at this location. The total

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fit-up and welding operations were completed between assembly members during the QA Inspector's shift.

The QA Inspector was notified by QC Inspector ABM Non-Destructive Testing technicians performed Ultrasonic Testing on the completed welds made on the Supplemental Cable Band Collars during the last shift and that Caltrans verification would be needed so ABM could continue with the fabrication.

Supplemental Cable Band CCO # 274 - Ultrasonic Testing Verification

The QA Inspector performed random Ultrasonic Testing (UT) verification on Complete Joint Penetration (CJP) "T" joint welds made between assembly plate members attached to the Supplemental Cable Band Collar identified as number 13 and 12. The QA Inspector did not observe any rejectable welding discontinuities during the verification. Please note that the QA Inspector followed the rejection and acceptance criteria table number 6.3 from the AWS D1.5 code. Please see the QA Inspector Ultrasonic Testing Report (TL- 6027) generated on this date for additional information. The QA Inspector notified QA Task Leader Michael Foerder and Structural Materials Representative (SMR) Yiannis Kourakis (in behalf of Gary Thomas) of the UT verification. Please see note below:

NOTE: The QA Inspector completed the UT verification on the Supplemental cable Band Collars scheduled for the project on this date. A total of 16 Cable Bands Collars were fabricated as per plan.

OBG Cable Safety Railing Coating - CCO # 188

The QA Inspector periodically observed ABM coating personnel performing coating operation. The coating operations were being performed on the OBG Cable Safety Railing (Post). The QC Inspector Tony Corsaletti notified QA Inspector ABM was stating the coating operation on this date on the cable safety railing. The material was located on the coating room and that the environmental readings were taken prior to the starting of the coating and during the operation. The QC Inspector listed the environmental readings into the QC Inspection log located on site. The coating operation was not completed during this shift and the QA Inspector was notified that the coating operation will be performed during the night shift on this date.

Summary of Conversations:

As noted on the body of the report above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
